

Date: Monday, 14/04/2008 1:07:33 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: 3"SKIDTUBE LIGHT "I" BEAM EXTRUSION		
Job Number	: 38589			Part Number	: D26005108		
Estimate Number	: 10306			Drawing Number	: D2600 REV D1		
P.O. Number	:			Project Number	: N/A		
This Issue	: 14/04/2008	S.O. No.	:	Drawing Revision	: D1		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: PURCHASED PARTS	Due Date	: 30/04/2008		
Previous Run	: 29985			Qty:	240		
Written By	:			Um:	110 Each		
Checked & Approved By	: JLO 08-4-14						
Comment	: Est F 02.09.10 Added DSK 066 KJ/RF						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
		 Comment: Issue P/O: <u>1665</u> 110 C 08/04/17 110 240 <ul style="list-style-type: none"> a) Extrude as per Dwg D2600 b) Material: 6061-T6 (QQ-A-200/8) c) Minimum yield tensile strength = 35 ksi d) Minimum ultimate tensile strength = 40 ksi e) Minimum elongation = 8% f) Order at 108" long g) Carandon Indalex Tool # MS-18871 h) To be packed per DSK 066 i) Pull test to ASTM standard B221 required. j) Material certification is required
2.0	D26005108P	Extrusion 'I' Beam' thin
		 Comment: Qty.: 1.0000 Each(s)/Unit Total : 110.0000 Each(s) EXTRUSION "I" BEAM THIN
3.0	PACKAGING 1	PACKAGING RESOURCE #1
		 Comment: Receive & Inspect For Transit Damage Ensure certification is attached
4.0	QC6	DIMENSIONAL CHECK
		 Comment: DIMENSIONAL CHECK <ul style="list-style-type: none"> 1-Inspect dimensions per Dwg D2600 2-Check Pull test per Dwg D2600 for compliance page attached. 3-Check hardness with Webster tester

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 14/04/2008 1:07:34 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 3"SKIDTUBE LIGHT "I BEAM EXTRUSION

Job Number: 38589

Part Number: D26005108

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 26

08.05.05

230

6.0 QC21

FINAL INSPECTION/W/O RELEASE



08/05/06 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>DKY</i>	DRAWN BY <i>DKY</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>SAS</i>	DRAWING NO. D2600	REV. D SHEET 1 OF 5
DATE 98.08.20	TITLE EXTRUSION		SCALE 1:1
A	97.01.21	NEW ISSUE	
B	97.09.09	CHANGE MATERIAL SPEC.	
C	98.04.16	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	
D	98.08.20	INCREASE MIN. UTS TO 40 KSI	
D1	01.04.17	ADD PART NUMBERS + DIE NUMBERS <i>+ GP</i>	

RELEASED
 18.08.25 DS

GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi
 MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
 MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED
 TO ASTM STANDARD B221 BY AN APPROVED TESTING
 FACILITY TO ENSURE THAT THE BATCH MEETS THE
 ABOVE MINIMUM MECHANICAL PROPERTIES.

2. BREAK ALL SHARP CORNERS 0.010 MAX.

3. NO TOOLING MARKS.

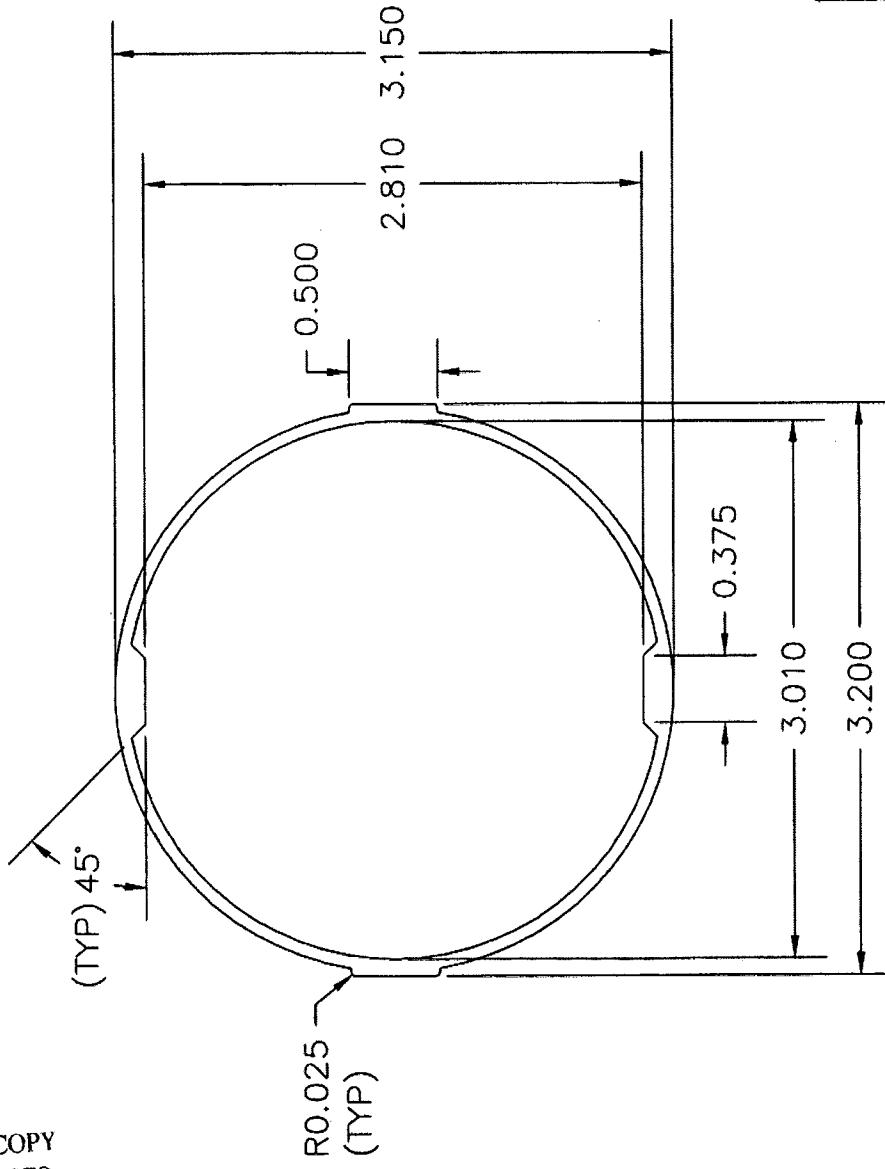
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE
 NOTED.

5. ALL DIMENSIONS ARE IN INCHES.

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 WITHOUT NOTICE
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 NO. *3888*

DARTOF COPY
03/02

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DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED
98.8.25 DSD2600-1

MANUFACTURED WITH CARADON INDALEX DIE # MH-18870
or BON L DIE # 897121 (PREFERRED CHOICE)
PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-1-160 IS 160" Long)

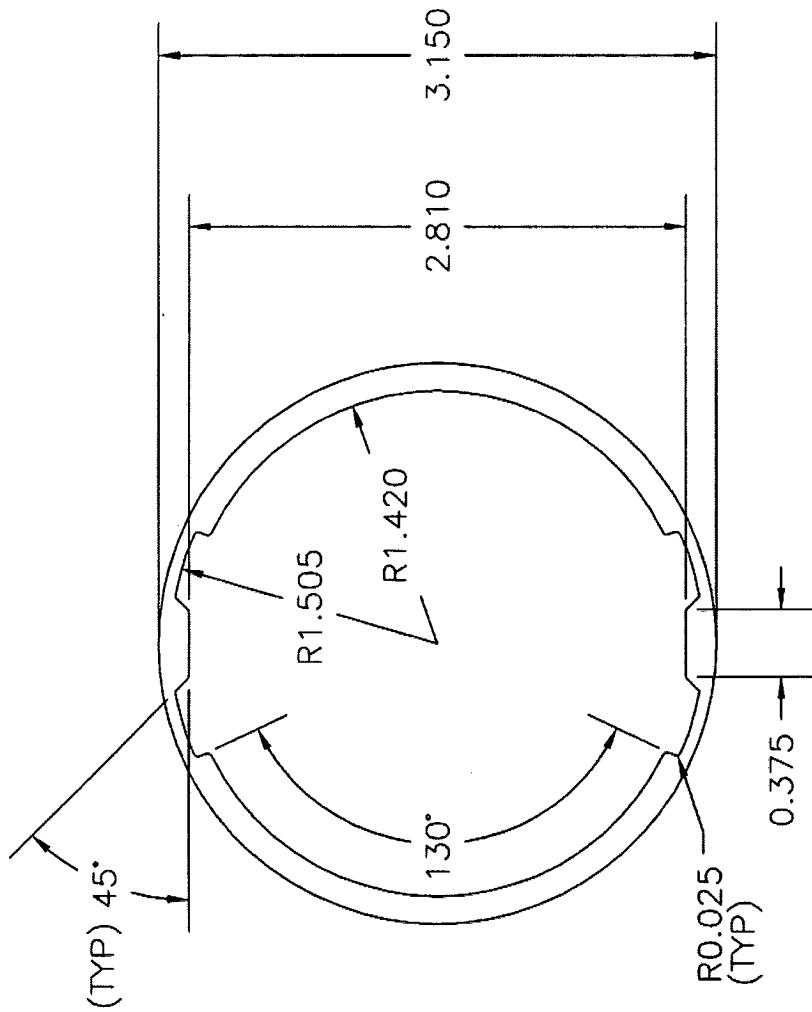


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DESIGN	DRAWN BY	DART AEROSPACE LTD	
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KE	GT	D2600	SHEET 3 OF 5
DATE	TITLE	EXTRUSION	SCALE 1:1
98.08.20			

RELEASED
98.8.25 DS

D2600-3

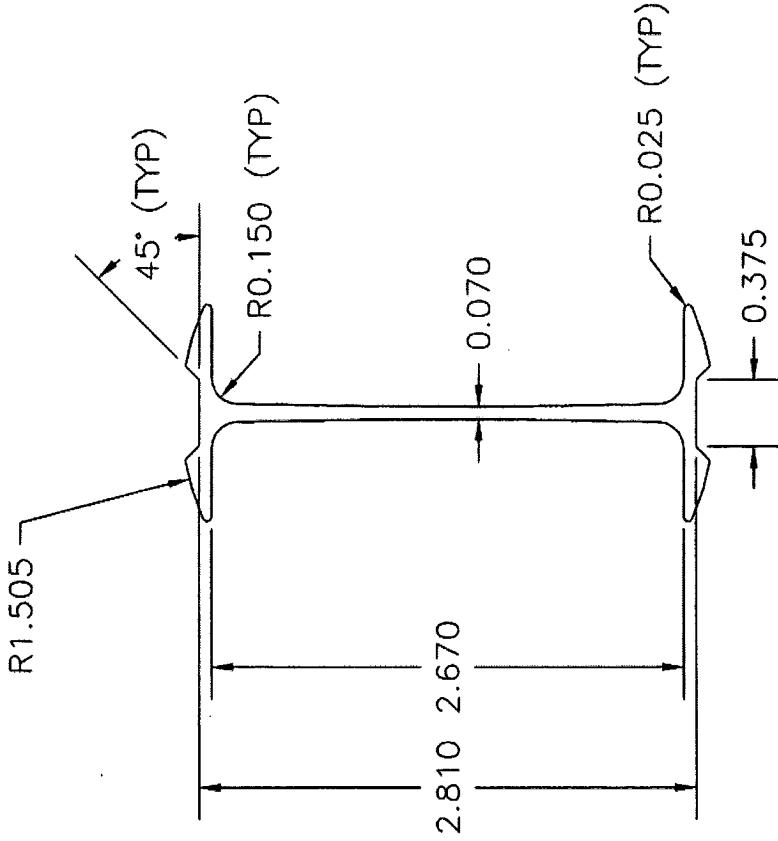
MANUFACTURED WITH CARADON INDALEX DIE # MH-18859
OR BON L DIE # 897122 (PREFERRED CHOICE)
PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (E.G. D2600-3-120 IS 120" long)



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KE	J	D2600	SHEET 4 OF 5
DATE		TITLE	SCALE
98.08.20		EXTRUSION	1:1

RELEASED
98.8.25. DS

D2600-5

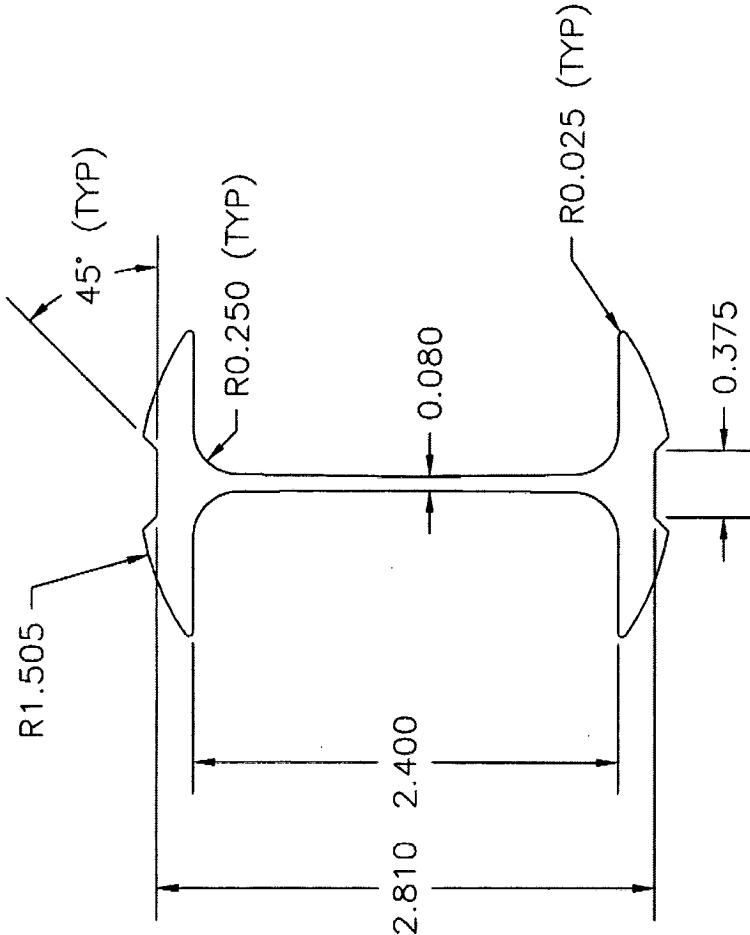
MANUFACTURED WITH CARADON INDALEX DIE # MS-18871
PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH IN INCHES
(E.G. D2600-5-108 IS 108" LONG)



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CHECKED	APPROVED	DRAWING NO.	REV. D
RE	AS	D2600	SHEET 5 OF 5
DATE	98.08.20	TITLE	SCALE
		EXTRUSION	1:1

RELEASED
98.8.25 DSD2600-7

MANUFACTURED WITH CARADON INDALEX DIE # MS-18872
PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES
(E.G. D2600-7-125 IS 125" LONG)



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INDALEX LIMITÉE
325, RUE AVRO
POINTE-CLAIRE (QUÉBEC) H9R 5W3
TÉL.: 514-697-5120 · FAX 514-694-8310

PROFILÉS D'ALUMINIUM - ANODISATION - FABRICATION - PEINTURE ALUMINUM EXTRUSIONS - ANODIZING - FABRICATION - PAINTING

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ONT

EXPÉDIÉ / SHIP TO

**INDICATIONS SPÉCIALES
SPECIAL INSTRUCTIONS**

P/S# : 656504

NOTRE NUMÉRO DE COMM.
OUR ORDER NO.

3041731-1

K6A1K7

CUSTOMER P.S.T. : *6122-5207

INDALEX G.S.T. REG NO: R136834041

PROJ:

NR DU CLIENT CUST NO.	T.P.S. G.S.T.	TAXE DE VENTE PROV. PROV. SALES TAX	NR DE COMM. DU CLIENT CUST. ORDER NO.	DATE DE COMMANDE ORDER DATE	NOTRE DATE DE COMM. OUR ORDER DATE	CONDITIONS TERMS		
201355	XXXXXX		6165	8/04/17	8/04/17			
VENDEUR SALESMAN	EXPÉDIE PAR SHIP VIA	PAYE PPD	PERC. COL.	C.A.D. C.O.D.	F.A.B. T.O.B.	EN BALLOTS BUNDLED AND TAPE	CARTONNE CARTONED	CARTONNÉ & INTERCALE CARTONED & INTERLEAVED
5	NOTRE CAMBRI							

OUR TRUCK		OUR PLATE				
ITEM NO	COMMANDE / ORDERED	N DE MATRICE INDALEX DIE NO.	DESCRIPTION DU CLIENT CUSTOMER DESCRIPTION	ALLIAGE ET TREMPAGE ALLOY AND TEMPER	LONGUEUR LENGTH	PRIX UNITAI UNIT PRIC
	POIDS WEIGHT	PIÈCES PIECES				
F EXTRUDE ONLY						
1	500	240	MS 18871 D2600-5	6061 T6	2743	
			D-2600-5 LIGHT DUTY			
			BUNDLE= 824324 824328			

We hereby certify that the material supplied meets the chemical properties as published by the Aluminum Association and requirements of our Quality procedures.

The logo consists of a laurel wreath surrounding the text 'ISO 9001'. The wreath is symmetrical, with leaves on the left and right sides. The text 'ISO' is at the top, and '9001' is at the bottom, all in a bold, serif font.

**EXEMPLAIRE DE LA COMPTABILITÉ
ACCOUNTING COPY**

**FEUILLE D'EMPAQUETAGE
PACKING SLIP**



INDALEX LIMITED
325 AVRO Street
POINTE-CLAIRE, QC H9R 5W9
TELEPHONE: (514) 697-5120 & (800) 563-5120
FACSIMILE: (514) 694-8310 & (800) 563-8310

FACSIMILE TRANSMITTAL SHEET

TO: Christina Young	FROM: Bruno Morency
	Quality Technician
COMPANY:	DATE:
DART AEROSPACE LTD	2008/04/30
FAX NUMBER:	TOTAL NO. OF PAGES INCLUDING COVER:
1(613) 632-4443	2
PHONE NUMBER:	SENDER'S REFERENCE NUMBER:
SUBJECT:	TIME:
REPORT	

URGENT FOR REVIEW PLEASE COMMENT PLEASE REPLY PLEASE RECYCLE

NOTES/COMMENTS:

Mechanical propctics report.

FAXED
30AP08

THIS COMMUNICATION IS INTENDED ONLY FOR THE PARTY NAMED BELOW AND MAY CONTAIN INFORMATION THAT IS PRIVILEGED AND CONFIDENTIAL. IF YOU ARE NOT THE INTENDED RECIPIENT OR THE PERSON RESPONSIBLE FOR DELIVERING THIS COMMUNICATION TO THE INTENDED RECIPIENT, YOU ARE HEREBY NOTIFIED THAT ANY DISCLOSURE, COPYING, DISTRIBUTION, OR THE TAKING OF ANY ACTION IN RELIANCE UPON THE CONTENTS OF THIS COMMUNICATION IS STRICTLY PROHIBITED. IF YOU HAVE RECEIVED THIS COMMUNICATION IN ERROR, KINDLY NOTIFY THE SENDER IMMEDIATELY BY TELEPHONE AND RETURN THE ORIGINAL TO US BY MAIL.



325 rue Avro
Pointe-Claire QC H9R 5W3

Téléphone (514) 697-5120
Fac-simile (514) 694-8310

Rapport des propriétés mécaniques Mechanical Properties Test Report

Client / Customer : DART AEROSPACE LTD

Adresse / Address : 1270 ABERDEEN STREET
HAWKESBURY ONT,
K6A 1K7

commande Indalex / Indalex order # : 8041731

FAXED
BOIROS

bon de commande / Purchase order # : 6165

de matrice / Die # : MS 18871 Description : D-2600-5 Light Duty Web

Aliage & trempage / Alloy & temper : 6061 T6

Contrôle / Control # : 73081-1

Coulée / Cast # : 43238

	Min. requis Min. required	Résultat actuel Actual results
Tension ultime Ultimate stress (psi)	38 000	38812
Contrainte élastique Yield stress (psi)	35 000	35434
% élongation dans 2" % elongation in 2"	8	12
Dureté Rockwell E (hrc) Rockwell E Hardness (hrc)	88 @ 100	90

Composition chimique typique / Typical chemical composition :

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti
6063	0.20 - 0.60	0.35 Max	0.10 Max	0.10 Max	0.45 - 0.90	0.10 Max	0.10 Max	0.10 Max
6005	0.60 - 0.90	0.35 Max	0.10 Max	0.10 Max	0.40 - 0.60	0.10 Max	0.10 Max	0.10 Max
6005A	0.68 - 0.72	0.15 - 0.27	0.08 - 0.12	0.20 - 0.24	0.48 - 0.52	0.03 Max	0.05 Max	0.03 Max
6061	0.40 - 0.80	0.70 Max	0.15 - 0.40	0.15 Max	0.80 - 1.20	0.04 - 0.35	0.25 Max	0.15 Max
6351	0.7 - 1.3	0.5 Max	0.10 Max	0.40 - 0.80	0.40 - 0.80	—	0.20 Max	0.20 Max

Nous certifions que le matériel fourni rencontre les exigences chimiques telles qu'annoncées par la norme ASTM B-221 excepté pour la section 8.2 (nombre de spécimen) et AMS QQA 200/8 excepté pour la section 4.2.3.1 (nombre de spécimen) qui sont déterminés par les exigences du client.

We hereby certify that the material supplied meets the chemical properties as published by the ASTM B-221 except for section 8.2 (number of specimen) and AMS QQA 200/8 except for section 4.2.3.1 (number of specimen) which is determined by customer requirement.

Sincèrement vôtre,

Yours truly,

date : 2008-04-30

Bruno Morency
Technicien de la qualité
Quality technician